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D3391-023
Job Sheet 176043



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J SHEET 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/23/18	0.00	0.00	Start Up Skidtubes-1		Jay
100	Skidtubes	1 pcs		5/23/18	0.88	2.11	Skidtubes-4		4 M/L
110	QC	1 pcs		5/23/18	0.00	0.00	QC5		SA 18-5-25
120	HandFinish	1 pcs		5/23/18	0.00	0.38	HandFinish1		SA 18-05-25
130	QC	1 pcs		5/23/18	0.00	0.00	QC7-2		BE
140	Skidtubes	1 pcs		5/23/18	0.00	2.11	Skidtubes-4		M/L
150	QC	1 pcs		5/23/18	0.00	0.00	QC5		BE
160	Skidtubes	1 pcs		5/23/18	0.00	2.11	Skidtubes-4		BE M/L
170	QC	1 pcs		5/23/18	0.00	0.00	QC10		38 DAB
180	QC	1 pcs		5/23/18	0.00	0.00	QC5		9-88 38
185	HandFinish	1 pcs		5/23/18	0.00	0.38	HandFinish2		SA 18-06-18
191	SprayPaint	1 pcs		5/23/18	0.00	0.91	Spray Paint		AR JUN 1 8 2018
192	Outsource	1 pcs		5/23/18			ATE003-VC		N/R
193	Packaging	1 pcs		5/23/18	0.00	0.00	Packaging2		N/R
200	QC	1 pcs		5/23/18	0.00	0.00	QC14		18-6-22
230	HandFinish	1 pcs		5/24/18	0.00	0.38	HandFinish4		18-6-25
240	QC	1 pcs		5/24/18	0.00	0.00	QC5		AK 18-6-25
250	Packaging	1 pcs		5/24/18	0.00	0.00	Packaging3-1		18-6-20
260	QC21-SA	1 Ea		5/24/18	0.00	0.00	QC21		21 JUN 2 6 2018

Part Op 100 - Cut tube to finish length as per Dwg D3391-023 Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1
Descriptions: fwd saddle hole on one side only as per Dwg D3391-023 3- Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle
holes 4- Remove .030" from Fwd indexing Ridge as per Dwg D3391-023 5- Remove indexing ridge on Fwd & Aft end of
skidtube as per Dwg D3391-023 6- Deburr, scribe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view
F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149
locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer
drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to
0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021
BATCH: 5064618 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,
DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG Locating from two fwd wearplate holes in D3391-023
drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail
section Q-Q to Ø0.375" (10 holes) as per Dwg D3391-023 Open wearplate holes of D3391-023 assembly detail section H-H to
Ø0.297" (20 holes) as per Dwg D3391-023 Deburr and blow out all chips from inside tube, scribe

DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	
NCR No. _____		Suspected Unapproved ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	
Date: _____		Step #: _____		QTY Effective: _____	
Description Work Order Deviation				Disposition	
				Completed By	
Root Cause					
Environment ☐		Pressure/Forced ☐			
Design ☐		Bending ☐			
Doc/Data ☐		Centre Not Conce ☐			
Equip/Tooling ☐		Cracks ☐			
Handling/Pre ☐		Crimp/Kink/Ripple ☐			
Material ☐		Cuffs ☐			
Internal Transport ☐		Crushing ☐			
Tribal Knowledge ☐		Heat Treat ☐			
LOA ☐		Wave/Twist in Tube ☐			
Substation ☐		Marks/Chatter ☐			
Past Expiry Date ☐		Instructions Incomplete/Unclear ☐			
Misidentified ☐		Fit/Function ☐			
		Misaligned/off center ☐			
		Misread ☐			
		Turning Sequence ☐			

DART AEROSPACE

Container No: S074152

Part: D3391 - 023

Job No: 176043

Serial No/Batch: S074152

Revision: J

Inspector:

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Date: 05/24/18

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140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 18-12-22 batch#: 138787
 NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE
 160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush A/A 138834
 185 - Re-alodine
 191 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 138862 PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: 138863
 230 - 1-Install Inserts as per Dwg

004049

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skidtube Extrusion	1 Ea (1 ea)	90-Start up Operation	<u>8163253</u>
D3389-1	Web	1 Ea (1 ea)	140-Skidtubes	<u>5062811</u>
D3681-1	Spacer	5 Ea (5 ea)	160-Skidtubes	<u>5022530</u>
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish	<u>5008959</u>
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	<u>5002403</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	59	0
140-Skidtubes	D3389-1	1	2	0
160-Skidtubes	D3681-1	5	248	0
230-HandFinish	ALS4-1032-130	20	14,777	0
	D3591-1	2	55	0

Part Specifications

Specifications could not be found.

